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# ISSUANCES

of the  
**Meat and Poultry Inspection Program**

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PROCEDURE  
CURRENT

AUGUST 1980



F  
S  
Q  
S

## CONTENTS

Changes

80-8, Meat and Poultry Inspection  
Manual

80-8, Meat and Poultry Inspection  
Regulations

**UNITED STATES DEPARTMENT OF AGRICULTURE**  
**Food Safety and Quality Service**  
**Meat and Poultry Inspection Program**  
**Washington, D.C. 20250**





UNITED STATES DEPARTMENT OF AGRICULTURE  
FOOD SAFETY AND QUALITY SERVICE  
MEAT AND POULTRY INSPECTION PROGRAM  
WASHINGTON, D.C. 20250

## Meat and Poultry Inspection Manual

August 1980

CHANGE: 80-8

### MAINTENANCE INSTRUCTIONS

Remove Page	Insert Page	Numbered
153 and 154	153 and 154	80-8

#### Pen-and-Ink Changes

1. Page 251, section 22.38(c)(1)(i)6, change to read, "Trichinae treated pork tongues are eligible for shipment".
2. Page 252, section 22.38(c)(iv), add a new number 3 to read as follows:  
"3. The pork was treated to a minimum internal temperature of 149° F. for at least 10 minutes".



3. Use of stainless steel tables and deboning pans.

4. Complete rinsing of tables, floors, etc., during work interruption, at lunch breaks, and when practical at rest period, and thorough cleanup during scheduled change of work shifts.

5. Frequent dismantling and cleaning of dicing equipment, grinders, etc., (at midshift and at end of each work shift, or more frequently when deemed necessary by the inspector in charge).

6. Rapid cooling of deboned product. Cooked and/or deboned product should be processed or cooled within 2 hours from the time of exposure to room temperature.

#### **(h) Mechanical Deboning**

Mechanical deboning of poultry is acceptable provided the equipment is approved by FESD. Approval must also be obtained concerning water, salt, etc., that may be introduced to deboned end product through use of equipment.

\* \* \*

\* Plant management is responsible for assuring product compliance by supplying the inspector with bone equivalent data (R-381.117(d)). A commercial laboratory may obtain the method for determining bone equivalent by contacting the Science Program.

Product may be used or shipped before receiving laboratory results. If such results are in violation, each future lot will be held pending laboratory analysis until inspector is assured of a return to general product compliance.

Inspector shall assure that compliance is maintained by occasionally sending a production sample to MPI laboratory. Sampling frequency depends upon accuracy of plant results and compliance history.

#### **(i) Brine Flotation**

Brine flotation systems used in deboning have been approved. However, certain requirements are necessary to maintain brine and equipment sanitation:

1. Unless otherwise approved, all brine tanks shall be drained and sanitized after 4 hours of operation.

2. Reserve brine tanks shall be drained and sanitized every 2 hours.

3. A continuous overflow of brine shall be maintained during operation. Overflow shall be sufficient to maintain a wholesome solution. Special procedure in handling deboned poultry is not permitted unless outlined in approved formula for product to be further processed.

### **18.38 BAKING, ROASTING**

#### **(a) Meat**

Pizza; trichinae control. Pizza with pork prepared and distributed frozen from preparing plant, or pizza with pork prepared on unbaked shell is classified as an article well cooked before eating and need not be treated for trichinae.

Pizza prepared on prebaked shells and refrigerated may not be sufficiently cooked; therefore, the pork must be treated to destroy possible live trichinae.

Pizza toppings with pork (mixtures of tomato paste, pork, etc.), prepared and shipped as such must be treated to destroy possible live trichinae since product's use cannot be controlled.

#### **(b) Poultry**

The term "roasted" denotes a method of cookery and not necessarily the appearance of finished product. When "roasted" is used with product name, product shall be cooked in presence of dry heat. However, such cooking may take place in presence of humidity, when added for facilitating heat transfer or efficiency.

When product is placed in a casing, the casing must be either pervious or perforated to allow drain of cooked out juices. Alternatively, a wrapping which is impervious may be turned down or removed for the final portion of cooking to provide for the drain off of cookout juices. If product is cooked through the entire cooking cycle in an impervious casing, such product does not qualify to be labeled "roasted." The finished product must have the appearance and characteristic of fully cooked, ready-to-eat foods.

#### **18.39 STEAMING, BOILING (POULTRY)**

Steaming or boiling may be done in ovens, pressure cookers, or retorts. When steam is used in direct contact with edible products, only specifically approved boiler compounds can be used.

#### **18.40 FRYING**

##### **(a) Meat**

Length of time fats and oils may be used for deep fat frying varies with temperature, quantity of new fat added daily, and fat treatment during use.

Suitability of these fats for further use can be determined from degree of foaming during use or from color, odor, and flavor.

Excessive foaming, darkened color and objectionable odor or flavor are evidence of unsuitability and require fat rejection.

Fat or oil should be discarded when it foams over the vessel's side during cooking, or when its color becomes almost black as viewed through a colorless glass container.

Serviceable life of fat can be extended by holding frying temperature below 400° F., daily replacing one-third or more, filtering as needed, and cleaning the system at least weekly.

Adding an antifoam agent (methyl-polysiloxane) to new fat is helpful.

##### **(b) Poultry**

Heat processing by deep fat frying may be performed in continuous frying machines with endless belt type equipment, or in batch-type open kettles. When poultry products are precooked with moist heat, followed by battering and breading to render them ready-to-fry, they are not considered fried products of the ready-to-eat variety.

**(1) Reinspection.** Reinspection of poultry products before battering, breading, and frying is necessary to determine whether they are ready-to-cook.

##### **(2) Battering and breading.**

Battering and breading may be done in one operation or separately. Mixtures for battering or breading may be prepared from individual components, or they may be purchased ready-mixed. Where commercial mixtures are used, the inspector limits the use to brands specified in label approval. Those mixed at the plant are strictly limited to approved formula. Components in these mixtures must be properly listed in the ingredients statement on the approved label for the finished product.

Amount of batter and breading permitted on fried poultry parts varies



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MEAT AND POULTRY INSPECTION REGULATIONS

AUGUST 1980

CHANGE: 80-7/8

MAINTENANCE INSTRUCTIONS

Remove Page

Insert Page (numbered 80-7/8)

SUBCHAPTER B - VOLUNTARY INSPECTION AND CERTIFICATION  
SERVICE OF MEAT AND POULTRY

49

49

50

50

SUBCHAPTER C - MANDATORY POULTRY INSPECTION

33

33

34

34

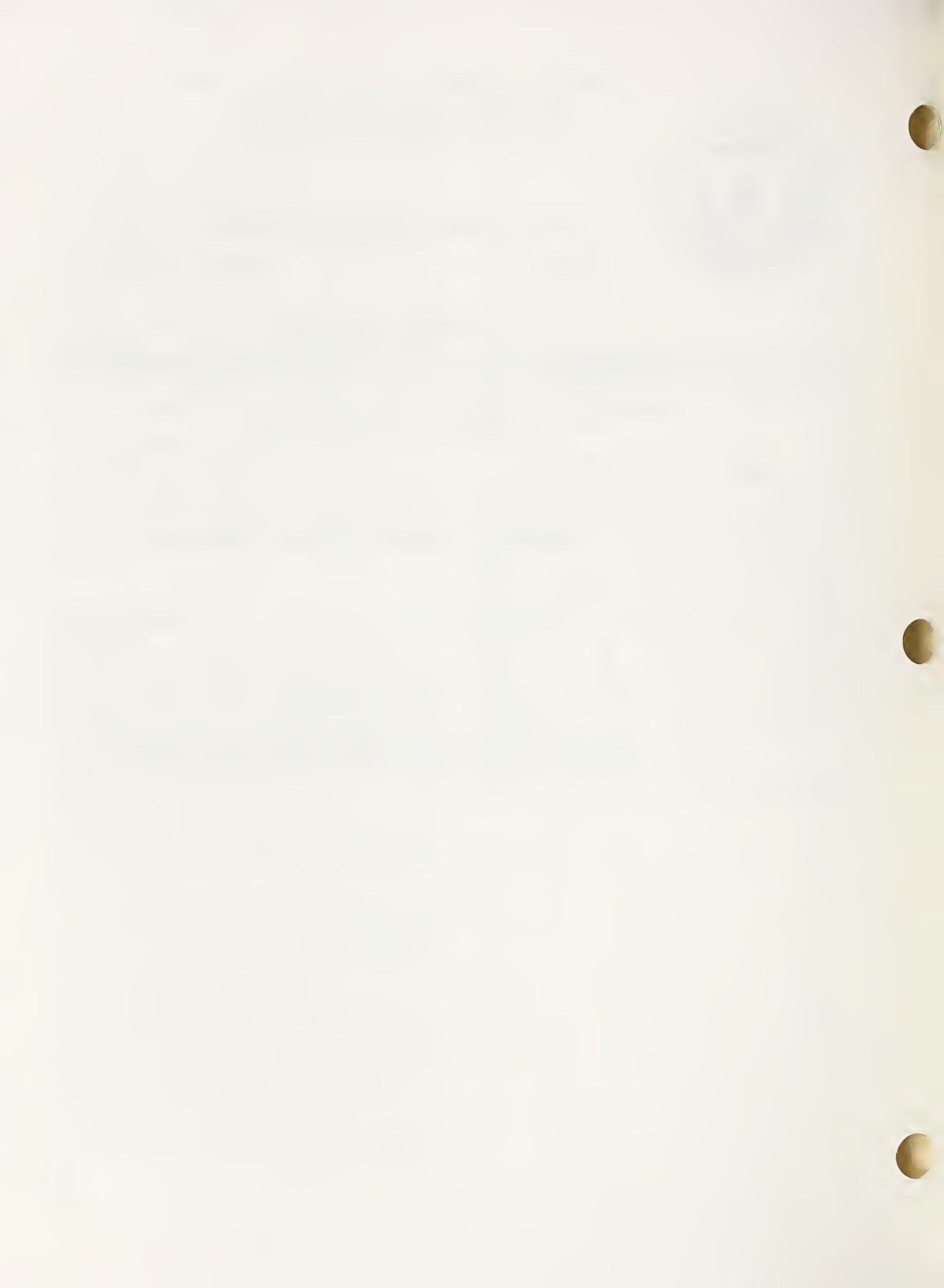
35

35

36

36

NOTE: These regulation changes are published only to correct  
previous typographical errors on aforementioned pages.



inspected plants or for new structures at such plants shall be submitted to the Administrator and approval obtained for the plans in advance of construction.

#### INSPECTION PROCEDURE

##### § 355.19 Inspector to be informed when plant operates.

The management of an inspected plant shall inform the inspector or the circuit supervisor when work in each department has been concluded for the day, and the day and hour when work will be resumed therein. There shall be no preparation of certified products at an inspected plant except under the supervision of an inspector.

##### § 355.20 Inspector to have access to plant at all times.

For the purpose of examination or inspection necessary to enforce any of the provisions of this part, inspectors shall have access at all times by day or night, whether the plant is being operated or not, to every part of an inspected plant.

##### § 355.21 Products entering inspected plants.

All products of a kind certified under this part or materials to be used in the preparation of such products when brought into an inspected plant shall be identified and inspected at the time of receipt and be subject to further inspection in such manner and at such time as may be deemed necessary. If, upon inspection, any such article is found to be unsound or otherwise unfit,  
\* it shall be handled as provided in § 355.28.

##### § 355.22 Designation of place of receipt of returned products.

Certified products returned to an inspected plant shall be received at a dock or place specifically designated for the purpose by the plant management with the approval of the circuit supervisor. Such returned products shall be inspected there by the inspector before further entering the plant.

##### § 355.23 Tagging products "U.S. retained."

A "U.S. Retained" tag shall be placed by an inspector at the time of inspection on all certified products, materials to be used in the preparation of certified products, or containers thereof, whenever such certified products, materials, or containers are suspected of being unsound or otherwise unfit or not in conformity with the requirements contained in this part. Such tags so placed shall not be removed by anyone other than an inspector.

##### § 355.24 Processes to be supervised.

All processes used in the preparation of the certified products shall be

supervised by an inspector. All steps in the process of manufacture shall be conducted carefully and with strict cleanliness. Inspected plants shall not prepare products of a kind certified under this part unless they conform with the regulations contained in this part.

§ 355.25 Canning with heat processing and hermetically sealed containers; closures; code marking; heat processing; incubation.

(a) Containers shall be cleaned thoroughly immediately before filling, and precaution must be taken to avoid soiling the inner surfaces subsequently.

(b) The inside surfaces of containers of metal, glass, or other material shall be washed by spraying in an inverted position with running water at a temperature of at least 180° F. The container washing equipment shall be provided with a thermometer to register the temperature of the water used for cleaning the containers.

(c) Perfect closure is required for hermetically sealed containers. Heat processing shall follow promptly after closing.

(d) Careful inspection shall be made of the containers by competent plant employees immediately after closing, and containers which are defectively filled or defectively closed, or which show inadequate vacuum, shall not be further processed until the defect has been corrected. The containers shall again be inspected by plant employees when they have cooled sufficiently for handling after processing by heating. The contents of defective containers shall be condemned unless correction of the defect is accomplished within six hours following the sealing of the containers or completion of the heat processing, as the case may be, except that (1) if the defective condition is discovered during an afternoon run the cans of product may be held in coolers at a temperature not exceeding 38° F. under conditions that will promptly and effectively chill them until the following day when the defect may be corrected; and (2) short vacuum or overstuffed cans of products which have not been handled in accordance with the above may be incubated as provided in paragraph (i) of this section in the inspected plant under Program supervision, after which the cans shall be opened and the sound products passed.

(e) Canned products shall not be passed unless, after cooling to atmospheric temperature, they show the external characteristic of sound cans; that is, the cans shall not be overfilled, the ends of the cans shall be concave, there shall be no bulging of the cans, the sides and ends of the cans shall conform to the products, and there shall be no slack or loose tin in the cans.

(f) All canned products shall be plainly and permanently marked on the containers by code or otherwise with the identity of the contents and date of canning. The code used and its meaning shall be on record in the office of the circuit supervisor before use.

(g) The canned products must be processed at such temperature and for such period of time as will assure keeping without refrigeration under usual conditions of storage and transportation as evidenced by the incubation test.

(h) Lots of canned products shall be identified during their handling preparatory to and during heat processing by tagging the baskets or cages in which the cans are being conveyed, with a tag which will change color on going through the heat processing or by other effective means so as to insure the proper channeling of the products for effective heat processing after closing the cans.

(§ 381.60(a)(2) continued)

for use and the precautions, if any, necessary in the use of such compound for the purpose intended in poultry processing establishments.

(b) As a prerequisite for approval, any compound which is required to be registered under the provisions of the Federal Insecticide, Fungicide, and Rodenticide Act shall be registered and comply with the provisions of that Act, \*the applicant shall furnish the registration number assigned under the aforesaid Act along with two copies of the label being currently used on the product.

(c) A small sample of the compound (4 to 6 ounces) shall be submitted with the request for approval of its use in poultry processing establishments.

(d) The Administrator will either approve or disapprove the use of a particular compound after a careful evaluation of the data submitted pursuant to paragraph (a) of this section and consideration of any other information that is available pertaining to the compound under consideration.

(e) The Inspection Service is authorized to draw samples of any compound used in any official establishment and make analyses of such compound to determine if the compound conforms to that originally approved and if it is satisfactory for use in official establishments under this section. Whenever the Administrator has reason to believe that a compound may have a deleterious effect on poultry or poultry products, the approval of the particular compound may be suspended, and in such case the processor shall be given an opportunity to show that the compound does not have such effect. After such opportunity has been afforded to the processor, the Administrator shall make a determination as to the effect of the compound on poultry and poultry products and withdraw or reinstate the approval of the compound accordingly. Use of the compound shall not be permitted during the period of suspension.

#### § 381.61 Cleanliness and hygiene of official establishment personnel.

(a) No official establishment shall employ, in any department where any poultry product is processed or otherwise handled, any person showing evidence of a communicable disease in a transmissible stage or known to be a carrier of such disease, or while affected with boils, sores, infected wounds, or other abnormal sources of microbiological contaminants.

(b) All persons coming in contact with exposed poultry products, or poultry products handling equipment shall wear clean garments and suitable head coverings to prevent hair from falling into poultry products; and shall keep their hands and fingernails clean at all times while thus engaged.

(c) Every person shall wash his hands thoroughly after each use of toilet or change of garments before returning to duties that require the handling of dressed poultry or other poultry products or containers thereof, or poultry product handling equipment.

(d) The use of tobacco in any form, the eating of food, or any other personal habit which may result in adulteration of any poultry product shall not be permitted in any room where exposed dressed poultry or other poultry products are being processed or otherwise handled.

## Subpart I-Operating Procedures

### § 381.65 Operations and procedures, generally.

(a) Operations and procedures involving the processing, other handling, or storing of any poultry product shall be strictly in accord with clean and sanitary practices and shall be conducted in such a manner as will result in sanitary processing, proper inspection, and the production of poultry and poultry products that are not adulterated.

(b) Materials which create any condition that may result in adulteration of poultry products shall not be handled or stored in rooms, compartments, or other places in any official establishment where any poultry product is processed, otherwise handled, or stored.

(c) Poultry shall be slaughtered in accordance with good commercial practices in a manner that will result in thorough bleeding of the carcasses and assure that breathing has stopped prior to scalding. Blood from the killing operation shall be confined to a relatively small area.

\* (d)-(g) [Reserved] \*

\* (h) Thawing poultry in water: \*

\* (1) Ready-to-cook poultry. When frozen ready-to-cook poultry is to be thawed in water, the thawing practices and procedures shall be such as will prevent the product from becoming adulterated by the absorption of moisture and such poultry shall be thawed by one of the following methods: \*

\* (i) The poultry may be thawed in continuous running tap water of sufficient volume and for such limited time as is necessary to thaw such poultry. The thawing media shall not exceed 70° F. in temperature. Complete thawing is

(§ 381.65(h)(1)(i) continued)

necessary to permit thorough examination of ready-to-cook poultry prior to any further processing.

\* (ii) The practice of placing frozen ready-to-cook poultry into cooking kettles, without prior thawing, is permitted only when a representative sample of the entire lot has been thawed and found to be sound and unadulterated. Thawing may be accomplished in cookers where the water can be heated to enable the cooking process to begin immediately following completion of thawing. Thawing practices and procedures shall result in no net gain in weight over the frozen weight. When whole carcasses or parts are thawed for repackaging as parts, it is not acceptable to recool the parts in slush ice. However, they may be held in tanks of crushed ice with the drains open, pending further processing or packaging.

\* (iii) The poultry may be thawed in recirculated water, maintained at a temperature not in excess of 50° F., for such limited time as is necessary to thaw such poultry.

\* (2) [Reserved]

\* (i) Cuts for the removal of the viscera shall be limited to those necessary for proper processing operations and inspection. With respect to roaster-style evisceration, opening cuts shall be made in such a manner that the skin between the thighs and rib cage will not be cut or torn open during the drawing operation. No additional cuts shall be made prior to chilling other than those necessary to perform the complete evisceration of the bird. The "bar-cut" method of evisceration may be used only when permitted by the inspector in charge upon his determination that this method can be used at the official establishment without contaminating the poultry. With respect to poultry that is to be opened by the "bar-cut" method, particular care shall be exercised in making transverse cuts so that the thigh areas will not be opened and the flesh at the posterior end of the keel will not be exposed. An occasional bird that is unintentionally opened in the aforesaid areas will be permitted. The type of opening cut is part of the chilling procedure and any change in such cut requires establishing a new procedure under § 381.66.

\* (j) The area at the junction of the neck with the body of the eviscerated bird shall be positively opened prior to final washing so that water will drain freely from the body cavity and not become trapped in the area between the neck skin and the neck.

\* (k) Ready-to-cook poultry shall be adequately drained after chilling, to remove ice and free water prior to packaging or packing.

\* (l) Cut-up poultry shall be processed from chilled carcasses and the parts shall not be rechilled in ice and water or water, but may be temporarily held in containers of crushed ice which are continuously drained pending further processing and packaging. Upon approval by the Administrator, and under such conditions as he may prescribe in specific cases, cut-up poultry may be processed from unchilled eviscerated poultry. Such poultry parts shall not

(§ 381.65(1) continued)

be chilled in water and ice, but may be chilled either in ice in continuously drained containers or by immediate entry into a freezer. Such poultry parts shall be chilled as provided in § 381.66 (b)(2).

\* (m) All offal resulting from the evisceration operation shall be removed \* from the official establishment as often as necessary to prevent the development of an insanitary condition.

\* (n) Containers to be used for packaging poultry products shall be \* clean, free from substances and odors that would result in adulteration of the products and of sufficient strength and durability to protect the products adequately during normal distribution.

\* (o) Paper and other material used for lining barrels or other containers \* in which poultry products are packed shall be of such kinds as do not tear readily during use but remain intact when moistened by the products. Wooden containers to be used for packing poultry products shall be fully lined except when the poultry products to be packed therein are fully wrapped.

\* (p) Protective coverings shall be used for poultry products while they \* are in any official establishment or are being transported between official establishments, which are adequate to protect the products against contamination by any foreign substances (including, but not being limited to, dust, dirt, and insects) considering the means employed in transporting the products.

\* (q) (1) Detached ova may be collected for human food in the official \* establishment provided it is done in a sanitary manner: Provided, the identity of such ova with the carcass shall be maintained past the point of inspection and ova from condemned carcasses shall likewise be condemned and treated as required in § 381.95: And provided further, That ova for human food are cooled packaged, and otherwise handled so as to be fit for human food.

(2) Detached ova harvested for human food may leave the official establishment only for movement to an egg products processing plant for processing as allowed in § 59.440 of the regulations (7 CFR 59.440) under the Egg Products Inspection Act and when moved from the official establishment shall bear labeling which indicates that the ova were harvested under sanitary supervision of the Inspection Service.

#### § 381.66 Temperatures and chilling and freezing procedures.

(a) General. Temperatures and procedures which are necessary for chilling and freezing ready-to-cook poultry, including all edible portions thereof, shall be in accordance with operating procedures which insure the prompt removal of the animal heat and will preserve the condition and wholesomeness of the poultry and assure that the products are not adulterated. A description of the chilling and freezing procedures used at the official establishment shall be filed with the inspector in charge at the establishment.

(b) General chilling requirements. (1) All poultry that is slaughtered and eviscerated in the official establishment shall be chilled immediately after processing so that the internal temperature is reduced to 40° F. or less, as provided in subparagraph (2) of this paragraph unless such poultry is to be



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